



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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2

D3391-025
Job Sheet 187432



Part No: D3391-025

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 1/22/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV J SHEETS 9,10,11 IPP Rev B 06-02-07 ECN773 dwg rev. D EC IPP Rev:C 06-03-28 Update
Manuf. Instructions JLM IPP rev D 07.03.20 revF dwg EC IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified
by: DD IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC IPP Rev:G 08-09-10 revH as per dwg DD verified
by:EC IPP Rev:H 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/22/19	0.00	0.00	Start Up Crosstubes		2019-02-20 DAS
100	Mori Seiki	1 pcs		1/22/19	2.49	4.17	Mori Seiki TL-40		2019-02-27 66
110	QC	1 pcs		1/22/19	0.00	0.00	QC2-1		2019-02-27 89
112	QC	1 pcs		1/22/19	0.00	0.00	QC5		FEB 28 2019
120	CNC Vertical Machining	1 pcs		1/22/19	0.00	2.63	HAAS1-3		KT 19-03-15
130	QC	1 pcs		1/22/19	0.00	0.00	QC2 Machining-2		KT 19-03-15
140	QC	1 pcs		1/22/19	0.00	0.00	QC8 Machining-2		2/19/03/17
150	Skidtubes	1 pcs		1/22/19	0.00	1.03	Skidtubes-4		M66
160	CNC Bend Skidtubes	1 pcs		1/22/19	0.00	1.33	CNC Bend Skidtube		M66
170	QC	1 pcs		1/22/19	0.00	0.00	QC5		BE
180	Skidtubes	1 pcs		1/22/19	0.00	1.03	Skidtubes-4		M66 DAS
190	QC	1 pcs		1/22/19	0.00	0.00	QC5		MAY 02 2019 68
200	HandFinish	1 pcs		1/22/19	0.00	0.58	HandFinish1		D.R 19/05/02
210	QC	1 pcs		1/22/19	0.00	0.00	QC7-2		M66
220	Skidtubes	1 pcs		1/22/19	0.00	1.41	Skidtubes-4		M66 DAS
230	QC	1 pcs		1/22/19	0.00	0.00	QC5		MAY 16 2019 68
235	HandFinish	1 pcs		1/22/19	0.00	0.58	HandFinish2		9-89
240	SprayPaint	1 pcs		1/22/19	0.00	0.25	Spray Paint	AL 19-5-23	MAY 22 2019
242	Outsource	1 pcs		1/22/19			ATE003-VC		NR
250	QC	1 pcs		1/22/19	0.00	0.00	QC14		FEB 19-05-24
260	HandFinish	1 pcs		1/22/19	0.00	0.58	HandFinish4		FEB 19-05-DAS
270	QC	1 pcs		1/22/19	0.00	0.00	QC5		JUN 21 2019 68
280	Packaging	1 pcs		1/22/19	0.00	0.00	Packaging3-1		PL 19-9-12/2019
290	QC21-SA	1 Ea		1/22/19	0.00	0.00	QC21		SEP 12 2019

Part Op 100 - Turn as per Folio FA599 Rev: J & Dwg D3391 Rev: J ***ensure steady rest is turning true*** REMOVE
 Descriptions: STEADY REST AND MACHINIG MARKS***

120 - 1-Machine as per Folio FA 599 Rev: J & Dwg D3391 Rev: J

140 - ***INSPECT INSIDE BORE***

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160 - Form as per Dwg D3391 Using Bend Prog 3391025

180 - 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391 (Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878 (Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size***** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5-Open wearplate holes to 0.297" and c'bore as per dwg D3391 6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8- Scribe batch # on fwd end

220 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 3140437 exp. date: 11-10-31 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Deburr

235 - AND REALODINE AS PER PAR09-043

240 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 Primer 5163577 Paint 5179047

260 - 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 5174342
 Sikaflex expiry date: 12/12 3- INSTALL WEARPLATES AS PER DWG

290 - 5- Detail DD, open (5) forward wearplate holes 0.375", then use DT10247 and drill holes for nutplates and c'sink. 6- Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX FARTHEST AFT HOLES ONLY*** 7-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8-Deburr 9- Scribe batch # on fwd end

DAS 59 9-89

FG 106

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6014-090	Aluminum Extrusion	1 Ea (1 ea)	90-Start up Operation	F139427
D3670-4-200	Bushing	4 Ea (4 ea)	220-Skidtubes	S123080
ALS4-1032-130	Rivnut	8 Ea (8 ea)	260-HandFinish	S057257
ALS4-1032-225	Rivnut	4 Ea (4 ea)	260-HandFinish	3x S152643/11 S149432
AN3C4A	Bolt	6 Ea (6 ea)	260-HandFinish	S143675
AN3C5A	Bolt	4 Ea (4 ea)	260-HandFinish	S156446
D2646	Aft Cap	1 Ea (1 ea)	260-HandFinish	S160607
D3672-1	Washer, Phenolic	2 Ea (2 ea)	260-HandFinish	F164008
D4095-047	Wearpad Aft	1 Ea (1 ea)	260-HandFinish	S070710
D4095-049	Wearpad Aft	1 Ea (1 ea)	260-HandFinish	S118505
MS20601-AD4W3	Rivet	12 Ea (12 ea)	260-HandFinish	S092 687 (M) S160312 SA
MS20601-AD4W7	Rivet	8 Ea (8 ea)	260-HandFinish	M137149
MS21075L5	Nut Plate	10 Ea (10 ea)	260-HandFinish	S093726
NAS1149C0332R	Washer	10 Ea (10 ea)	260-HandFinish	S148669
				M.U. 009476

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6014-090	1	4	0
220-Skidtubes	D3670-4-200	4	48	0
260-HandFinish	ALS4-1032-130	8	11,083	0
	ALS4-1032-225	4	1,280	0
	AN3C4A	6	1,647	0
	AN3C5A	4	1,492	0
	D2646	1	42	0
	D3672-1	2	1,403	0
	D4095-047	1	33	0
	D4095-049	1	25	0
	MS20601-AD4W3	12	501	0
	MS20601-AD4W7	8	33	0
	MS21075L5	10	310	0
	NAS1149C0332R	10	3,437	0

Part Specifications

Specifications could not be found.

Plex 12/4/18 11:34 AM dart.white.jesse



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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S155249



Part: D3391-025

Job No: 187432

Serial No/Batch: S155249

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/20/19

②

DART AEROSPACE LTD		Work Order: 187432
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		Tape	
3.500	+/-0.010	3.499	✓		CNC-08	
Ø3.200	+/-0.010	3.209	✓		CNC-05	
Ø3.750	+/-0.010	3.754	✓		CNC-05	
30° x 0.060 chamfer	+/-0.010	.068	✓		CNC-08	
88.93	+/-0.030	88.93	✓		Tape	

Measured by: DAS 66 M.D.	Date: 2019-02-27
Audited by: 9-89	Date: FEB 28 2019

HAAS Section						
1.526	+0.000/-0.030	1.505	✓		Kt-05	VerM.
7.500	+/-0.010	7.500	✓		"	"
27.750	+/-0.010	27.750	✓		Tape	—
31.750	+/-0.010	31.750	✓		"	"
35.250	+/-0.010	35.250	✓		"	"
3.300	+/-0.010	3.300	✓		KT-05	VerM.
0.200	+/-0.010	0.200	✓		"	"
3.520	+/-0.010	3.524	✓		"	"
0.687	+0.010/-0.000	0.689	✓		"	"
R0.062	+/-0.010	0.0625	✓		—	R-G
Ø0.484	+0.005/-0.001	0.484	✓		Kt-05	VerM.

Measured by: DAS 1/28	Date: 2019-03-15
Audited by: 9-89	Date: 19/03/17

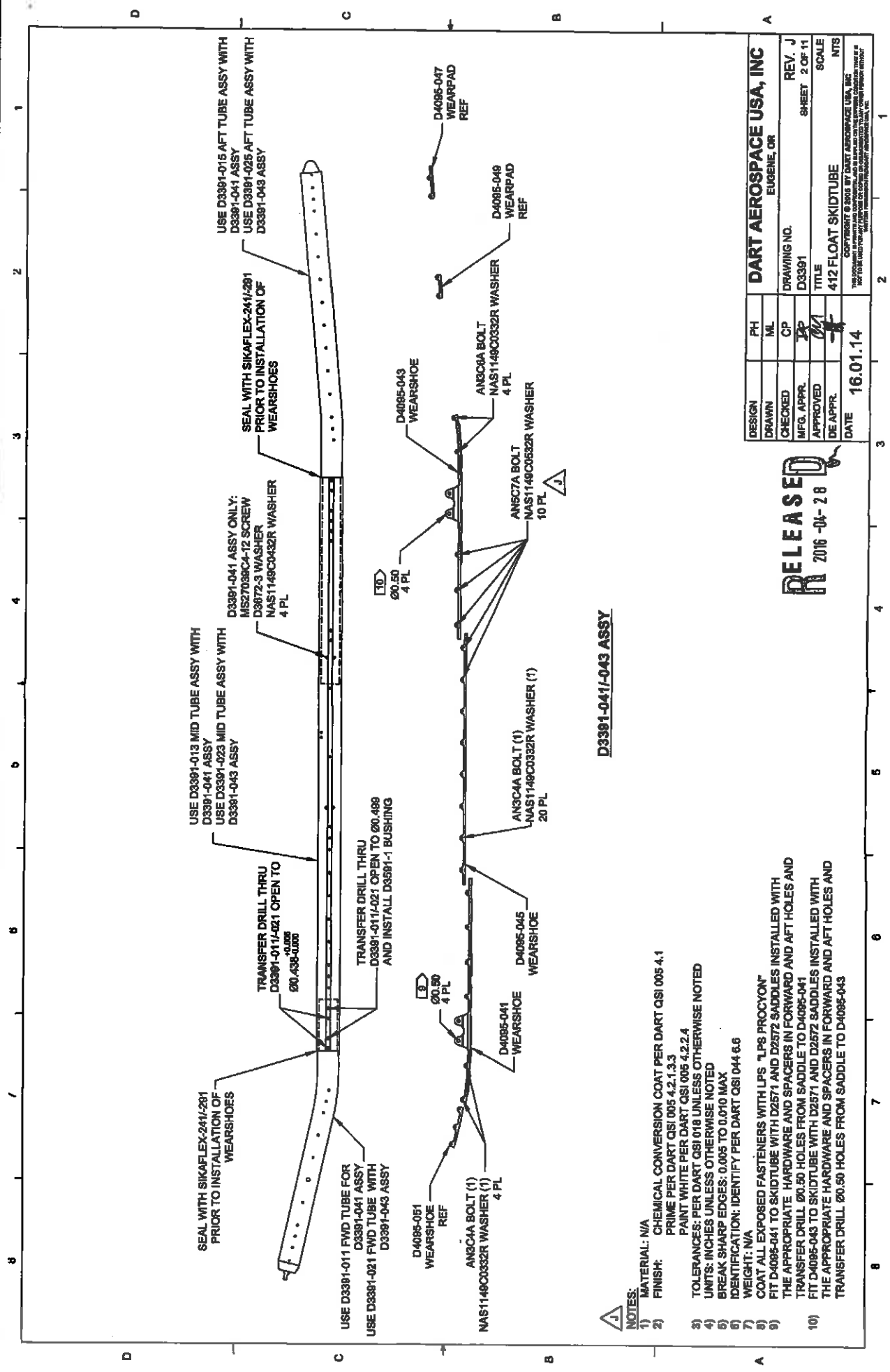
Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

QTY	PART NUMBER	DESCRIPTION
441	D3394-041	FLYGT SHOTUTUBE ASSEMBLY
1	D3391-043	FLYGT SHOTUTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3872-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
34	AN3CA	BOLT
4	AN3CA	BOLT
10	AN3CA	BOLT
28	NAS1140C032R	WASHER
10	NAS1140C032R	WASHER
28	MS2758CA-12	SCREW
4	NAS1140C0432R	WASHER

QTY	PART NUMBER	DESCRIPTION
441	D3394-041	FLYGT SHOTUTUBE ASSEMBLY
1	D3391-043	FLYGT SHOTUTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3872-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
34	AN3CA	BOLT
4	AN3CA	BOLT
10	AN3CA	BOLT
28	NAS1140C032R	WASHER
10	NAS1140C032R	WASHER
28	MS2758CA-12	SCREW
4	NAS1140C0432R	WASHER

RELEASED
2016-04-28
EON 16-916

J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED OBORE DOWEL (ZN D2-4, D2-6), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	16.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A5-1, ZN A3-2, ZN A4-4, ZN B0-4, LP3-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AEL5-1032-130, ZN B0-4, B2-4, C7-8, C3-9; REMOVED HOLES, ZN D0-4 ZN D2-4, ZN D7-4, ZN D3-3	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL, ADDED D3591-1 BUSHING, ZN 90.439 DIM WAS 4 PL, ADDED 90.489 DIM AND D3591-1 BUSHING. SHT 2 PL, ADDED D3591-1 BUSHING, ZN 90.439 DIM WAS 4 PL, ADDED 90.489 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAG INSERTS W/ AEL5 INSERTS SWITCH TO D3870-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.51
F	ADD S3 WEARSHOE, GASKET REMOVE PWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.29
C	LENGTHEN AFT EXTENSION	PH	06.09.27
B	UPDATE UPDATES	PH	06.06.10
A	NEW ISSUE	PH	06.02.07
REV	DESCRIPTION	BY	DATE
DRAWN	PH		
CHECKED	ML		
APPROVED	CP		
DE APPR.	DP		
DATE	16.01.14		



D3391-041/-043 ASSY



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.6
 - 7) WEIGHT: N/A
 - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
 - 9) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
 - 10) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

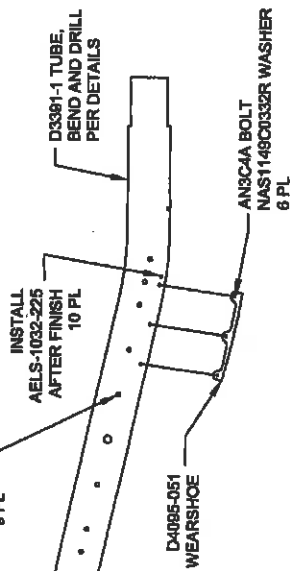
DESIGN	PH	ML	DRAWING NO.	REV.	J
DRAWN			D3391	SHEET	2 OF 11
CHECKED	CP			TITLE	SCALE
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	16.01.14				

RELEASED
2016-04-28
412 FLOAT SKIDTUBE
DART AEROSPACE USA, INC.
EUGENE, OR

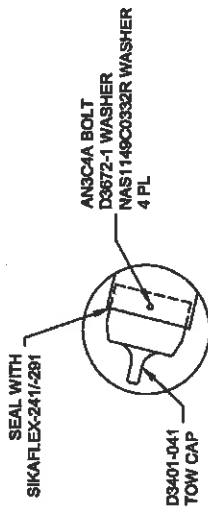
DART AEROSPACE USA, INC.
EUGENE, OR

INSTALL D3870-4200 SPACER
SEAL WITH MAGNABOND 6398
GRIND FLUSH
PRIOR TO PAINTING
9 PL

DETAIL A



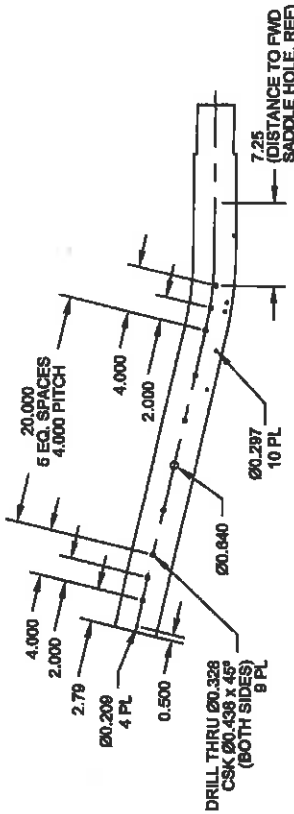
D3391-011 FWD TUBE ASSEMBLY ASSEMBLY DETAIL



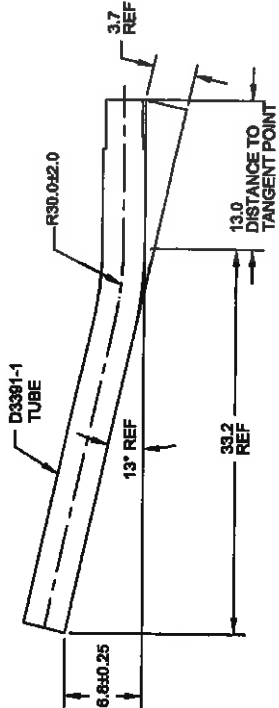
DETAIL A SCALE 2X

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3870-4200	SPACER
4	D3672-1	WASHER
1	D4085-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1148C0332R	WASHER



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL (MAKE FROM D3391-1)

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	ML	EUGENE, OR
CHECKED	CP	DRAWING NO. D3391
MFG. APPR.	CP	REV. J
APPROVED	CP	SHEET 3 OF 11
DE APPR.	CP	TITLE 412 FLOAT SKIDTUBE
DATE	16.01.14	SCALE NTS

RELEASED
R 2016-04-28

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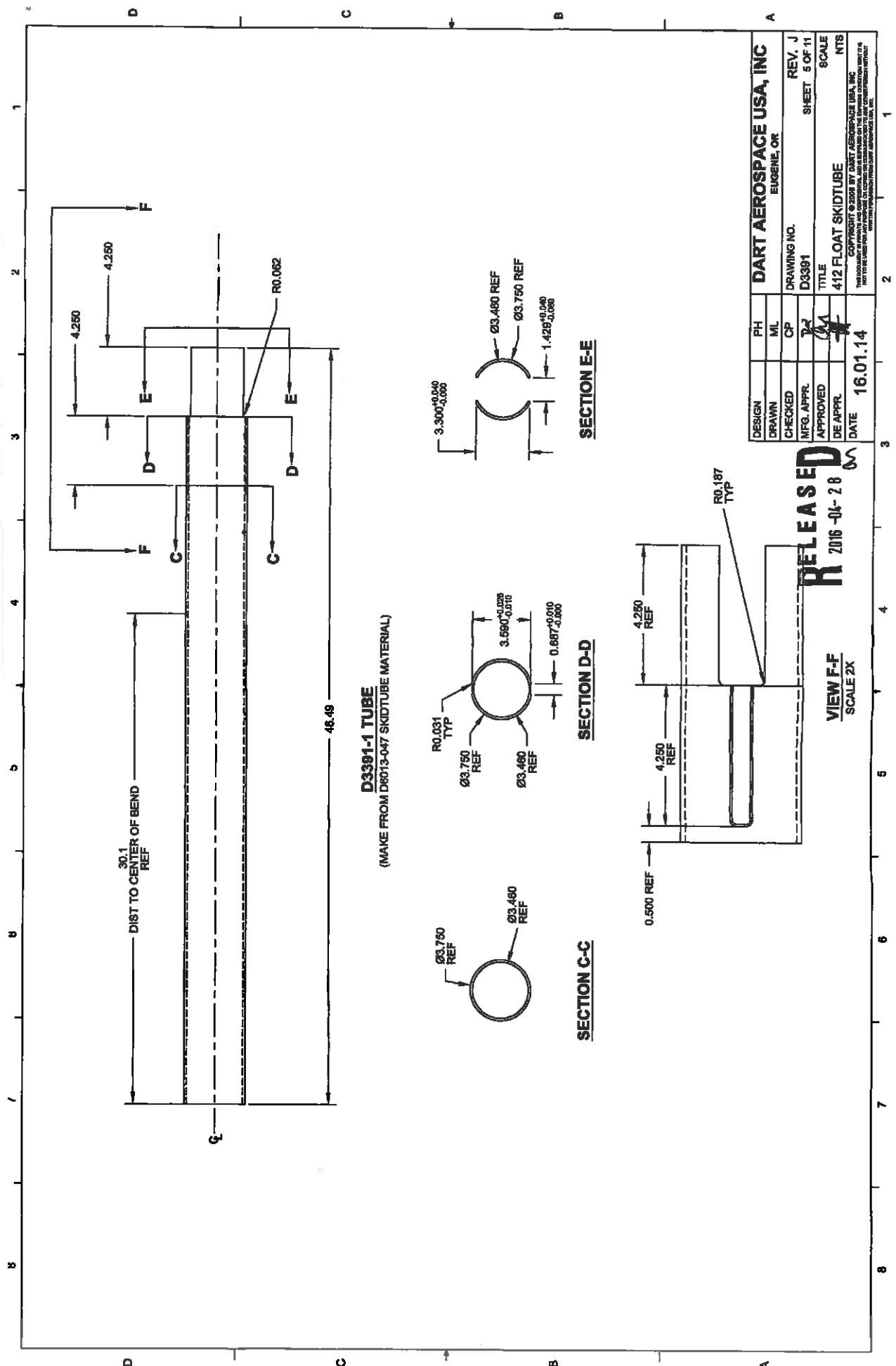


QTY	PART NUMBER	DESCRIPTION
4021		
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-0200	SPACER
4	D3872-1	WASHER
1	D4085-051	WEARSHOE
10	AE1S-1032-225	INSERT
10	AN3CA1	BOLT
10	MA5114907332R	WASHER

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	ML	EUGENE OR		
CHECKED	CP	DRAWING NO.	REV. J	
MEG. APPR.	DP	D3391	SHEET 4 OF 11	
APPROVED	BY	TITLE	SCALE	NTS
DE APPR.	BY	412 FLOAT SKIDTUBE		
DATE	16.01.14	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC		

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2016-04-28 RELEASED



D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

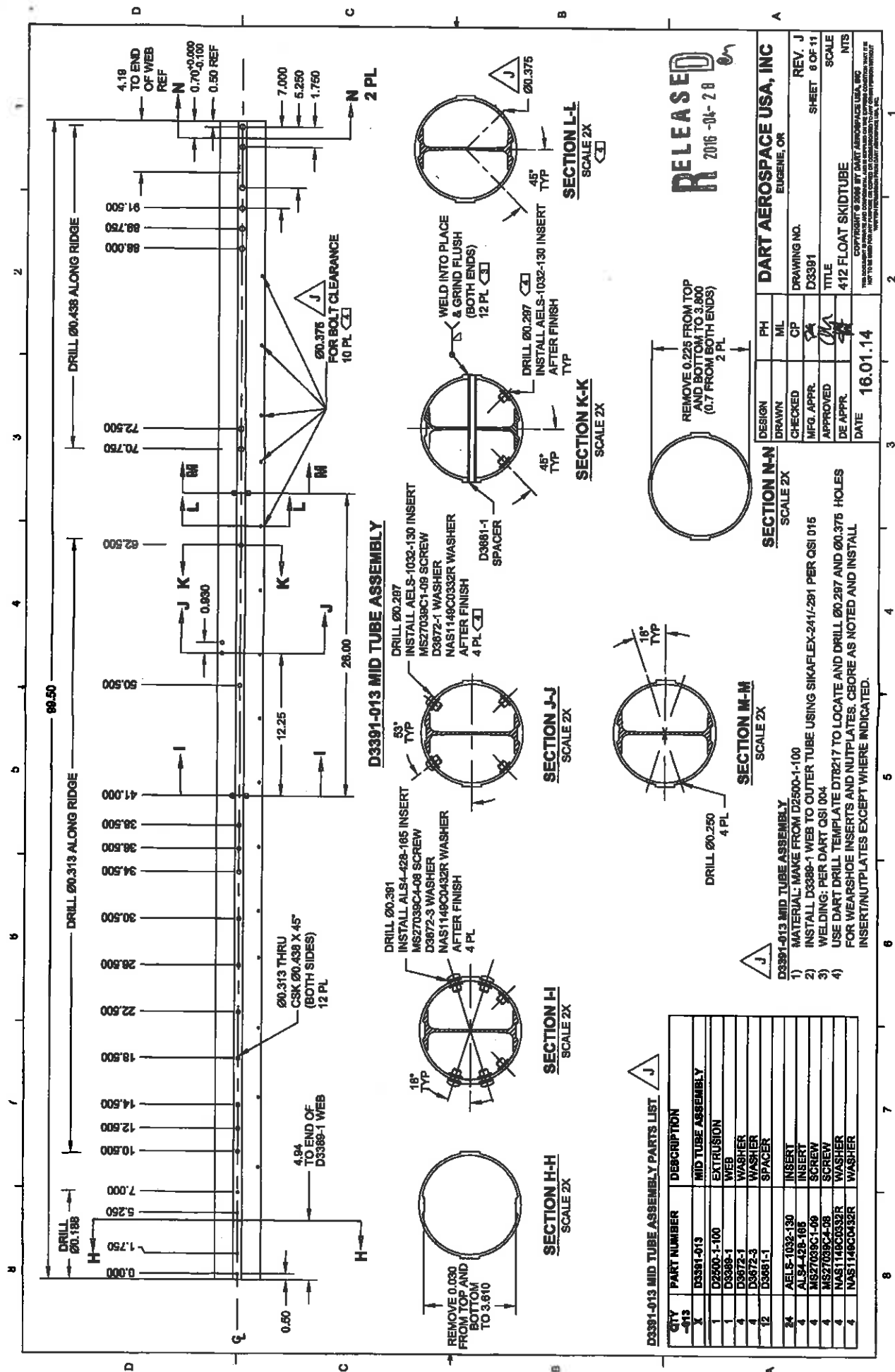
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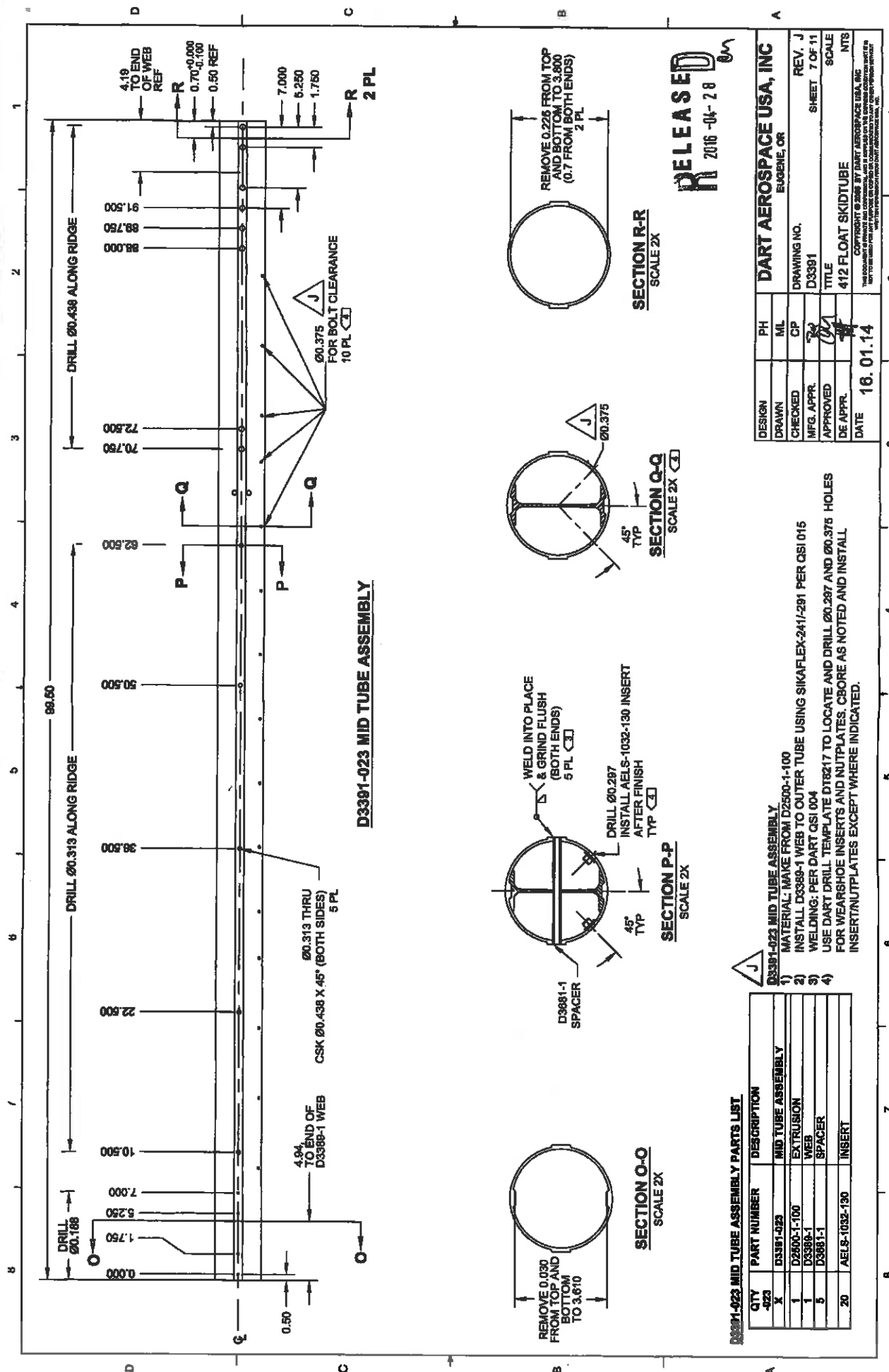
SECTION D-D

SECTION C-C

VIEW F-F
SCALE 2X

RELEASED
2016-04-28





RELEASED
2016-04-28

DESIGN	PH	ML	CP	CP	REV.	J
DRAWN						
CHECKED						
MFG. APPR.						
APPROVED						
DATE	18.01.14					

QTY	PART NUMBER	DESCRIPTION
1	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
5	D3398-1	WEB
5	D3398-1-1	SPACER
20	AELS-1032-130	INSERT

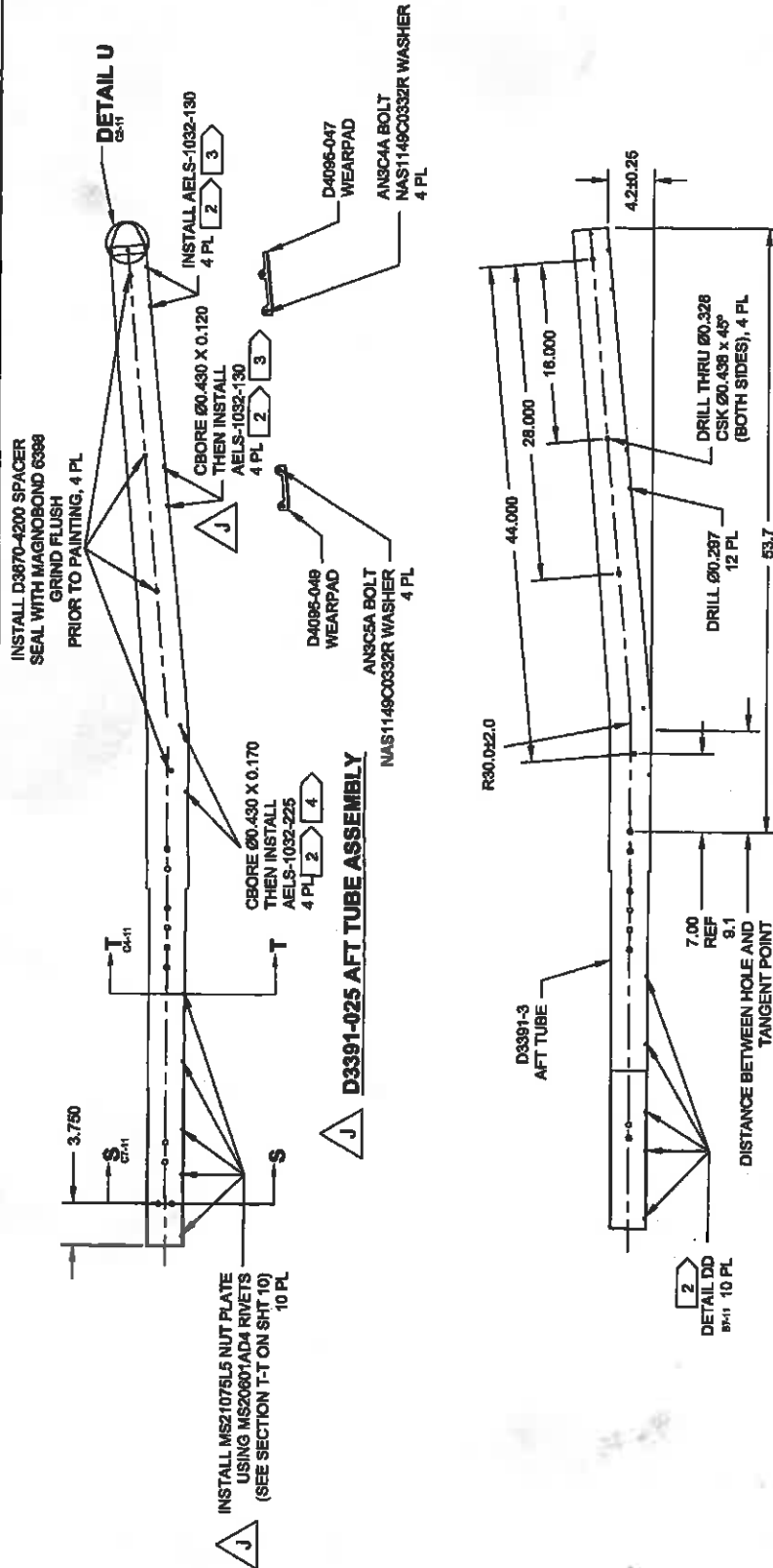
QTY	PART NUMBER	DESCRIPTION
1	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
5	D3398-1	WEB
5	D3398-1-1	SPACER
20	AELS-1032-130	INSERT

DART AEROSPACE USA, INC
EUGENE, OR

D3391-023 MID TUBE ASSEMBLY
MATERIAL: MAKE FROM D2500-1-100
INSTALL D3398-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
WELDING: PER DART QSI 004
USE DART DRILL TEMPLATES D18217 TO LOCATE AND DRILL Ø0.287 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.



RELEASED
R 2016-04-28



BENDING AND DRILLING DETAIL

D3391-025 AFT TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-025	AFT TUBE ASSEMBLY
1	D3870-4200	AFT CAP
1	D3391-3	AFT TUBE
4	D3870-4200	SPACER
2	D3872-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
1	AEL5-1032-130	INSERT
1	AEL5-1032-225	INSERT
1	AN5C4A	BOLT
1	AN5C5A	BOLT
1	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE FLOATING
10	AN51148C0332R	WASHER

NOTES:

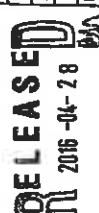
- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROTECTION"
- 2) USE DART DRILL TEMPLATE DTR217 TO LOCATE AND DRILL Ø0.287 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

DESIGN	PH	ML	DATE	16.01.14
DRAWN	CP	CP		
CHECKED	CP	CP		
MFG. APPR.	CP	CP		
DE APPR.	CP	CP		
TITLE				
AFT TUBE ASSEMBLY				
SCALE				
NTS				

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EUGENE, OR

DRAWING NO. D3391
REV. J
SHEET 9 OF 11



SECTION S-S
SCALE 5X

SECTION T-T DE-4.5
SCALE 5X
5 PL

DETAIL U_{D1-0.9}
SCALE 5X

DRILLING DETAIL DD
SCALE 10X
87-43

DETAIL EE
SCALE 2X
RM-11

DESIGN	PH	DART AEROSPACE USA, INC					
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MFG. APPROV	7-2	D3381		TITLE		SCALE	
APPROVED	10			AFT TUBE ASSEMBLY		NTS	
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2016-04-28 RELEASED

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.